

Split

Work Order ID 101883-1

May-21-13 7:44:39 AM

\*101883\*

Page 1

Item ID: D3975-042

Accept

\*N9000040100\*

Setup Start \*NS1\*

Revision ID:

Item Name: Gas Cylinder Assembly, RH

Stop \*NS2\*

Start Date: 5/21/13 Start Qty: 5.00

\*5\*

Cust Item ID:

Required Date: 5/28/13 Req'd Qty: 5.00

\*5\*

Customer:

Reference:

Approvals:

Process Plan: ~~MLJ~~

Date: 13-05-21

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D3975

B

110

0.00

\*110\*

Small Fab

Memo

0.00

Small Fab

apply decal as per dwg

2

0

FF  
13-05-22

120

QC5- Inspect part completeness to step on W/O

0.00

\*120\*

QC

Memo

0.00

Quality Control

DAS  
21  
BS 27

2

130

Identify as per dwg &amp; Stock Location: 5080

0.00

\*130\*

Packaging

Memo

0.00

Packaging

2x

SP  
13-5-30

**Work Order ID 101883**

May-21-13 7:44:39 AM

**\*101883\***

Page 2

Item ID: D3975-042

Revision ID:

Item Name: Gas Cylinder Assembly, RH

Start Date: 5/21/13 Start Qty: 5.00

Required Date: 5/28/13 Req'd Qty: 5.00

Reference:

Accept

**\*N900040100\***Setup Start **\*NS1\***Stop **\*NS2\***

Cust Item ID:

Customer:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***Stop **\*NR2\***Sequence ID/  
Work Center ID

140

**\*140\***

QC

Quality Control

Operation  
Description

QC21- Final Inspection - Work Order Release

Memo

Set Up/  
Run Hours

0.00

0.00

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp13/5/31 *[Signature]*

MF

13-5-30

# Picklist Print

May-21-13 7:44:43 AM

Page 1

Work Order ID: 101883

Parent Item: D3975-042

Parent Item Name: Gas Cylinder Assembly, RH

\*101883\*

\*D3975-042\*

Start Date: 5/21/13

Required Date: 5/28/13

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP RevA: New issue DD verified by:EC  
10.05.27 as per ECN10-548 DD verf:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3975-1

\*D3975-1\*

Gas Cylinder

Manufactured

No

110

Each

10.0000

1

5

\*\*

FF 13-05-22

Location

Loc Qty

Loc Code

GA

10

91873

10

52

D3976-3

\*D3976-3\*

Decal

Manufactured

No

110

Each

2.0000

1

5

\*\*

FF 13-05-22

Location

Loc Qty

Loc Code

ST081

2


60431

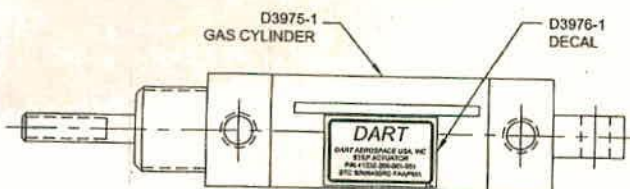
2

2

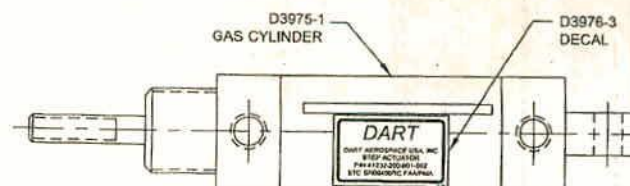
Pressure/Force	
Temperature/Force	
Weld	
Wrong Stock Picked	
Other	



ITEM No.	QTY	QTY	PART NUMBER	DESCRIPTION
1	X	-041	D3975-041	GAS CYLINDER ASSEMBLY (LH)
2		X	D3975-042	GAS CYLINDER ASSEMBLY (RH)
3	1	1	D3975-1	GAS CYLINDER
4	1		D3976-1	DECAL
5		1	D3976-3 	DECAL



**D3975-041 GAS CYLINDER ASSEMBLY**



**D3975-042 GAS CYLINDER ASSEMBLY**

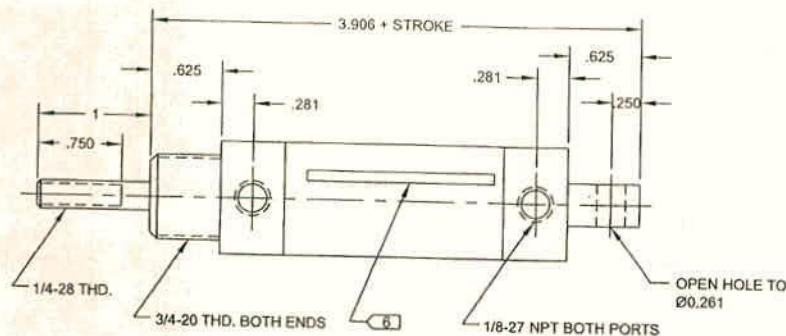
SHOWN COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 101883 MLJ

13-05-21

**RELEASED**  
2010-05-20

B	CORRECTED TYPO: D3976-3 WAS D3975-3 (ZN D7-1)	MB	10.04.13
A	NEW ISSUE	AJS	09.07.09
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	<b>DART AEROSPACE USA, INC</b>	
DRAWN		PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3975	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		GAS CYLINDER ASSEMBLY	NTS
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101883



**D3975-1 BRASS CYLINDER**

**NOTES:**

- 1) MATERIAL: CROSS REFERENCE Era DRAWING 41232-200-007  
PURCHASE P/N: HEAVY DUTY BRASS CYLINDER 7D1H  
VENDOR: CLIPPARD INSTRUMENT LABORATORY, INC, CINCINNATI, OH.
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH Era P/N 41232-200-007-001 USING VIBRATING STYLUS
- 7) WEIGHT: 0.74 lbs APPROX
- 2) BORE: 0.875 INCHES
- 3) ROD: ROTATING.
- 4) 7D1H CONFIGURED WITH HYD. FLUID SEALS.
- 5) TEMPERATURE RANGE: 30° F TO 230° F.
- 6) MOUNT: UNIVERSAL MOUNT.
- 7) ACTION: DOUBLE ACTING.
- 8) STROKE: 1.000 INCH.
- 9) POWER FACTOR: 0.6 SQ. IN.
- 10) PORTS: 1/8 NPT.
- 11) ROD DIAMETER: 0.25 INCHES.
- 12) SINTERED BRONZE ROD BUSHING.
- 13) PRESSURE TEST: 2660 PSI (USE 5606 FLUID).

**RELEASED**  
2010-05-20

DESIGN	ASS	<b>DART AEROSPACE USA, INC</b>	
DRAWN	J	PORT HADLOCK, WA	
CHECKED	P	DRAWING NO.	REV. B
MFG. APPR.	DS	D3975	SHEET 2 OF 2
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